

AG ship ASAP !!

Work Order ID 70962

Monday, June 20, 2011 11:39:10 AM



Item ID: DSI 9399-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heater Modification

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9399

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

8/10/12

Document Control

Photocopy bluefile and create labels as per PPP DSI 9399-011 CHG001

110

0.00



Packaging Preh hit

Packaging

Memo

0.00

Packaging

8/10/12

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/12

Quality Control

8/10/12

Work Order ID 70962

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Page 2

Item ID: DSI 9399-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heater Modification

Start Date: 6/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9399-011 □ Location: _____ □ PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

11/6/22 ①

11/6/22

11.06.22

Picklist Print

Monday, June 20, 2011 11:39:07 AM

Page 1

Work Order ID: 70962

Parent Item: DSI 9399-011

Parent Item Name: Heater Modification







Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-01-10 ECN 1075 DD
IPP Rev:B 08-01-28 ECN 1108 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN815-8D  Union-M-Flare		Purchased	No			120	Each	7.0000	1	1			
<div> <div>Location</div> <div>ST329</div> </div> <div> <div>Loc Qty</div> <div>7</div> </div> <div> <div>Loc Code</div> <div>114544</div> </div>													
D2003-011A  Tube Assembly-8J		Manufactured	No			120	Each	0.0000	1	1			
D2003-037A  Tube Assembly-8J		Manufactured	No			120	Each	0.0000	1	1			
D2005-015A  Hose Ass'y .375dia x 36"		Manufactured	No			120	Each	0.0000	1	1			
D2005-015B  Hose Ass'y .375dia x 36"		Manufactured	No			120	Each	0.0000	1	1			
D3717-1  Plate		Manufactured	No			120	Each	0.0000	3	3			

AN894D8-6

1 M106636

P70

Dart Aerospace Ltd

W/O: 70962		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/16/22	20	Permanent Change Add AN54486 to Bom	BE	11.06.23	N/A	[Signature]	6 11/16/23	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 11:39:07 AM

Page 2

Work Order ID: 70962

Parent Item: DSI 9399-011

Parent Item Name: Heater Modification

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3718-1

Manufactured No

120 Each

3.0000

1

1



Hose



gb

✓

Location

Loc Qty

Loc Code

ST195

3

36452

3

MS9387-08

Purchased No

120 Each

114.0000

1

1



"O" Ring



36452

gb

11/06/22

Location

Loc Qty

Loc Code

MEZZ

114

14674

114

14674

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-570 REV. C
& INSTALLATION DRAWING D206-570 REV. D
REF. TCCA STC: SH90-19
REF. FAA STC: SH810NE

To facilitate installation of the D206-570-145 heating system, the following changes are acceptable:

1. The existing AN804-8J tee fitting can be moved to the forward side of the forward firewall as shown in Figure 1.
2. The D3718-1 hose can be installed off the AN804-8J tee fitting and connected to the bleed air particle separator as shown in Figure 1.
3. The existing D2005-015 hose on the RH side of the valve assembly can be replaced with the D2005-015A hose.
4. The existing D2005-015 hose on the LH side of the valve assembly can be replaced with the D2005-015B hose.
5. The AN815-8D union, MS9387-08 O-ring and AN894D8-6 expander can be installed between the existing AN938-8D tee fitting on the RH side of the D206-570-049 valve assembly and the new D2005-015A hose as shown in Figure 2.
6. The existing D2003-037 tube can be replaced with the D2003-037A tube.
7. The existing D2003-011 tube can be replaced with the D2003-011A tube.
8. The D3717-1 plates can be transfer-drilled and installed using the existing nutplates on the vertical tunnel cover to secure the heater line in the vertical tunnel as shown in Figure 3.

Refer to sheet 2 for Figures 1, 2 and 3.

The following DSI-9399-011 kit is available to facilitate these changes:

QTY -011	Part Number	Description
X	DSI-9399-011	HEATER MODIFICATION KIT
1	D2003-011A	TUBE
1	D2003-037A	TUBE
1	D2005-015A	HOSE
1	D2005-015B	HOSE
3	D3717-1	PLATE
1	D3718-1	HOSE
1	MS9387-08	O-RING
1	AN815-8D	UNION
1	AN894D8-6	EXPANDER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01





APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 07.12.12

CERT. NO.: SH90-19

ISSUE NO.: 5

A	NEW ISSUE	LE	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9399	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HEATER MODIFICATION KIT	NTS
DATE	07.12.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-570 REV. C
& INSTALLATION DRAWING D206-570 REV. D

REF. TCCA STC: SH90-19
REF. FAA STC: SH810NE

REFERENCE ONLY

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3. The existing D2005-015 hose on the RH side of the valve assembly can be replaced with the D2005-015A hose.
4. The existing D2005-015 hose on the LH side of the valve assembly can be replaced with the D2005-015B hose.
5. The AN815-8D union, MS9387-08 O-ring and AN894D8-6 expander can be installed between the existing AN938-8D tee fitting on the RH side of the D206-570-049 valve assembly and the new D2005-015A hose as shown in Figure 2.
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



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1	D2003-037A	TUBE
1	D2005-015A	HOSE
1	D2005-015B	HOSE
3	D3717-1	PLATE
1	D3718-1	HOSE
1	MS9387-08	O-RING
1	AN815-8D	UNION
1	AN894D8-6	EXPANDER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 07.12.12
CERT. NO.: SH90-19
ISSUE NO.: 5

A	NEW ISSUE	LE	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		DSI 9399	SHEET 1 OF 2
MFG. APPR.	N/A	TITLE	SCALE
APPROVED		HEATER MODIFICATION KIT	NTS
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DATE	07.12.12		

